

Work Order ID 86276***86276***

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Tuesday, June 26, 2012 12:54:50 PM

Item ID: D3686-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: MONOPOD ASSEMBLY

Start Date: 6/26/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

mm

Date:

20626

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3686

E

100

Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

*1**φ**FF**12-07-09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Sequence ID/
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Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00

110

Small Fab

Small Fab

Memo

0.00

1- Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3686
*****ENSURE THERE IS ANTI-SEIZE ON FULL LENGTH OF THREAD*****

A/R Anti-Seize Batch: 11791

2- Assemble D3693-1 & D3691-1 & D3693-3 & D3688-7 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3686
***Ensure holes for AN3C Bolts are free of sealant.
Torque Fastners as per Dwg D3686***

A/R Sikaflex Batch: 121409

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

5/16/10



FF
12-07-09

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Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.00

Packaging

12-7-10

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

CK 12/7/11
mc

12-07-10

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Picklist Print

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Work Order ID: 86276
Parent Item: D3686-041
Parent Item Name: MONOPOD ASSEMBLY

Start Date: 6/26/2012 Required Date: 6/29/2012
Start Qty: 1.00 Required Qty: 1.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC
03-16 JLM VERIFIED BY:EC
IPP Rev:D Added sealant note as per Rev C 09-01-20 JLM
Verf:DD
revE DD verf:EC
IPP REV:C AS PER REV D 10-
IPP REV:E 11.12.05 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3688-7 STUD		Manufactured	No	81735		100	Each	0.0000	1	1	① FF	12-07-09	
D3689-1 SLEEVE		Manufactured	No	82358		100	Each	1.0000	1	1	① FF	12-07-09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST061	83350		1			1			
					72117		1						
D3691-1 STUD		Manufactured	No			100	Each	2.0000	1	1	① FF	12-07-09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA			2						
					78909		1						
					<u>80363</u>		1			1			
D3692-1 SPACER		Manufactured	No			100	Each	501.0000	4	4	① FF	12-07-09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST061			501						
					51467		16						
					<u>80364</u>		25			4			
					81729		100						
					81961		200						
					83257		100						
					85415		60						

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Parent Item Name: MONOPOD ASSEMBLY

Start Date: 6/26/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

D3692-3
SPACER

Manufactured No

100 Each 38.0000

4 4

① FF 12-07-09

Location	Loc Qty	Loc Code
ST061	38	
44690	7	
81737	31	

D3693-1
Rod End Bearing

Manufactured No

100 Each 61.0000

1 1

① FF 12-07-09

Location	Loc Qty	Loc Code
GA	59	
80275	1	
81738	20	
83612	38	
ST	2	
83612	2	

D3693-3
Rod End Bearing

Manufactured No

100 Each 9.0000

1 1

① FF 12-07-09

Location	Loc Qty	Loc Code
GA	9	
77720	5	
81893	4	

AN3C10A
Bolt

Purchased No

100 Each 44.0000

2 2

① FF 12-07-09

Location	Loc Qty	Loc Code
ST351	44	
112489	1	
119798	43	

MS21042-3
USE MS21042L3

Purchased No

100 Each 0.0000

2 2

① FF 12-07-09

121444

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D3686-041

Parent Item Name: MONOPOD ASSEMBLY

Start Date: 6/26/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

MS21043-3 Purchased No 100 Each 1,264.0000 2 2 ① FF 12-07-09
Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	72	
103691	72	
ST301	1192	
118077	2	
118614	26	
118686	30	
119758	20	
<u>121255</u>	172	
121708	942	

NAS509L12C Purchased No 100 Each 64.0000 1 1 ① FF 12-07-09
Nuts

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
279	10	
121652	10	
ST279	54	
112314	3	
112828	1	
<u>120498</u>	10	
121349	40	

NAS509-12C Purchased No 100 Each 114.0000 1 1 ① FF 12-07-09
Nuts

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST279	114	
<u>120422</u>	9	
121162	20	
121274	25	
121556	10	
121827	50	

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Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D3686-041
Parent Item Name: MONOPOD ASSEMBLY

Start Date: 6/26/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

MS21250-03014 Purchased No 100 Each 16.0000 2
BOLT

2 ① FF 12-07-09

Location

Loc Qty

Loc Code

ST305

16

119902

8

121283

8

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

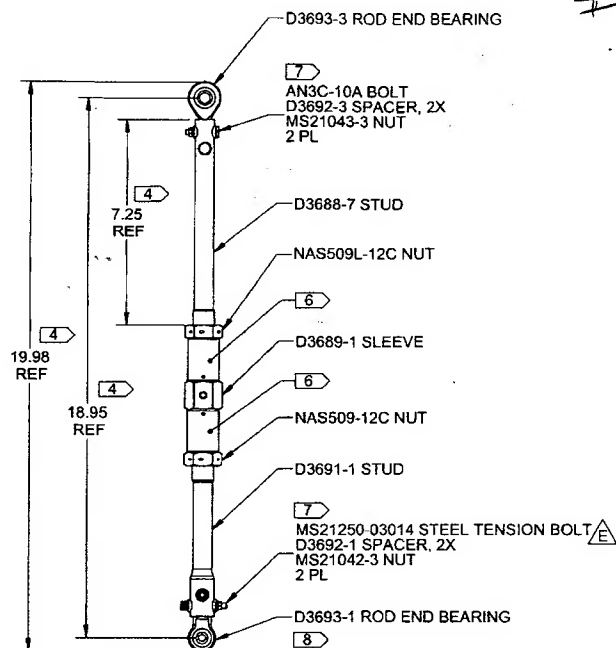
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3686-041	MONOPOD ASSEMBLY
2	1	D3688-7	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	4	D3692-3	SPACER
7	1	D3693-1	ROD END BEARING
8	1	D3693-3	ROD END BEARING
9	2	AN3C-10A	BOLT
10	2	MS21042-3	NUT
11	2	MS21043-3	NUT
12	2	MS21250-03014	STEEL TENSION BOLT
13	1	NAS509L-12C	NUT
14	1	NAS509-12C	NUT



D3686-041 MONOPOD ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3686-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-7 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.0 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 & D3693-3 WITH D3688-7 USING SIKAFLEX-2411-291 OR PROSEAL 890 OR MIL-S-8602 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

E	QTY(2) MS21250-03014 STEEL TENSION BOLTS AND QTY(2) MS21042-3 NUT REPLACE QTY(2) AN3C12A BOLTS AND QTY(2) MS21043-3 NUT (ZN B3-1 & C6/D6-1). REASON: PRODUCT IMPROVEMENT (REF. NOR11-784)	MB	11.11.23
D	19.98 WAS 20.10 (ZN C8-1); 18.95 WAS 18.07 (ZN C5-1)	RF	10.03.03
C	ROD END BEARINGS NOW ASSEMBLED USING SEALANT (ZN A8-1, B4-1)	RF	08.12.15
B	REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.11.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3686** REV. E
SHEET 1 OF 1
TITLE **MONOPOD ASSEMBLY** SCALE NTS

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